

## Claims

1. An opening structure of the container which continuously and integrally forms a cap portion and a pouring portion, wherein due to a radial deformation of an easy-to-break portion which is present in a boundary between the cap portion and the pouring portion, the easy-to-break portion is broken and hence, the cap portion and the pouring portion are separated thus opening the container.

2. The opening structure of a container according to claim 1, wherein a deflection deformation portion is provided in the vicinity of the easy-to-break portion, the deflection deformation portion is deformed by pressing in the inside direction from the outside thus generating the radial deformation of the easy-to-break portion.

3. The opening structure of a container according to claim 1 or 2, wherein the cap portion and the pouring portion are continuously and integrally formed of an inner wall, an intermediate wall which is folded back downwardly from an upper end portion of the inner wall, and an outer wall which is folded back upwardly from a lower end portion of the intermediate wall, and the easy-to-break portion is formed on the outer wall.

4. The opening structure of a container according to claim 3, wherein the deflection deformation portion is provided in a gap defined between the outer wall and the intermediate wall and/or in a gap defined between the intermediate wall and the

inner wall.

5. The opening structure of a container according to any one of claims 1 to 4, wherein the cap portion includes a cylindrical cover portion which is contiguously integrally formed with the easy-to-break portion and a disc-like ceiling plate portion which covers an opening portion of the pouring portion, and thread portions are formed on the cylindrical cover portion and the pouring portion which is contiguously formed with the cover portion.

6. The opening structure of a container according to claim 5, wherein along with the rotation of the cap portion in the cap opening direction from a cap-sealed state, a gap generated between the thread grooves of the pouring portion and the thread crests of the cap portion is gradually enlarged.

7. The opening structure of a container according to claim 6, wherein a width of the thread grooves of the pouring portion and a width of the thread grooves of the cap portion are gradually decreased downwardly.

8. The opening structure of a container according to claim 6, wherein a depth of the thread grooves of the pouring portion and a height of the thread crests of the cap portion are gradually decreased downwardly.

9. The opening structure of a container according to claim 6, wherein a width of the thread grooves of the pouring portion and a width of the thread crests of the cap portion are gradually decreased downwardly, and a depth of the thread grooves of the pouring portion and a height of the thread crests of the cap

portion are gradually decreased downwardly.

10. The opening structure of a container according to any one of claims 1 to 4, wherein the cap portion includes a cylindrical cover portion which is contiguously integrally formed with the easy-to-break portion and a disc-like ceiling plate portion which covers an opening portion of the pouring portion, and an undercut portion is formed in the cylindrical cover portion.

11. The opening structure of a container according to any one of claims 1 to 10, wherein a sealing material is arranged between an upper portion of an inner surface of the cap portion and the pouring portion.

12. The opening structure of a container according to any one of claims 1 to 11, wherein sub scores are formed adjacent to the easy-to-break portion.

13. The opening structure of a container according to any one of claims 1 to 12, wherein the deflection rigidity of the deflection deformation portion is set non-uniform in the circumferential direction.

14. The opening structure of a container according to claim 13, wherein the deflection deformation portion is embossed.

15. The opening structure of a container according to any one of claims 1 to 14, wherein an unopened guarantee material is provided to or in the vicinity of the deflection deformation portion or to or in the vicinity of the easy-to-break portion.

16. A container being characterized by including the opening structure of a container described in any one of claims

1 to 15.

17. A manufacturing method of an opening structure of a container, an enlarged-diameter portion is formed by enlarging a diameter of a cylindrical portion from the inside to the outside thereof, an easy-to-break portion is formed on the enlarged-diameter portion, the cylindrical portion is pressurized in the height direction such that an intermediate wall expecting portion which is formed on a center portion of the cylindrical portion in the height direction is formed into an intermediate wall, an outer wall expecting portion is folded back from above such that the outer wall expecting portion is arranged on an outermost side and forms an outer wall thus forming a projecting portion which is formed of cylindrical triplicate walls consisting of an inner wall, an intermediate wall and the outer wall, and a deflection deformation portion is formed between the outer wall and the intermediate wall and/or between the intermediate wall and the inner wall, and engaging portions are formed on the projecting portion.

18. The manufacturing method of an opening structure of a container according to claim 17, wherein in forming the enlarged-diameter portion by enlarging the cylindrical portion from the inside to the outside, a bulged annular portion is formed in the vicinity of a boundary between the outer wall expecting portion and the intermediate wall expecting portion, and a connecting portion having a diameter larger than a diameter of the intermediate wall expecting portion is provided below the bulged annular portion.

19. The manufacturing method of an opening structure of a container according to claim 17 or 18, wherein sub scores are formed adjacent to the easy-to-break portion.